

Work Order ID 131251

April-01-15 9:11:49 AM

Ship ASAP

131251

Page 1

Item ID: D3477-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blower Motor Inlet Adapter

Stop

NS2

Start Date: 4/01/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/08/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3477

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

4

FF

APR 02 2015

105

0.00

105

Purchasing

Memo

0.00

Purchasing

SEND TO GFI FOR SPOT WELDING

PER QSI004

PO 28039

CL 15/04/07 (4)

shipback. CL 15/04/22 (4)

108

Receive & Inspect for Damage & Mat'l Certs

0.00

108

Packaging

Memo

0.00

Packaging

SD CL 15/04/17 (4)

CL 15/04/27 x3

x1 no good

Pro

DQA:

Date:

15/05/21



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/05/21

Work Order update only ☐

Work Order: <u>131251</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3477-041</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5000</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☒	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	150407	105	①	gaps found between D3477-3 and D3477-1	 DAS 29 9-89	Scrap + destroy. REG NCR - we supplied incorrect material	DAS 38 9-89 APR 27 2021	DAS 9 9-89 1504-27	DAS 9 9-89 1504-27
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Pressure/Forced
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Over/Under tolerance
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Incorrect
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Part Moved
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Power Loss/Surge
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Pressure/Forced
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Set-up
☐ Wave/Twist in Tube	☒ Fit/Function	☐ Out of Sequence	☐ Temperature/Cure
			☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 131251

131251

Page 2

Item ID: D3477-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blower Motor Inlet Adapter
 Start Date: 4/01/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/08/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00							9
Quality Control									9-89
130	Identify as per dwg & Stock Location: ST226B	0.00							
130									DAS
Packaging	Memo	0.00							05
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(3) **15-04-27**

3

19-0

APR 27 2015

15-04-27

MF

15-4-27

Picklist Print

April-01-15 8:09:05 AM

Page 1

Work Order ID: 131251

131251

Parent Item: D3477-041

D3477-041

Parent Item Name: Blower Motor Inlet Adapter

Start Date: 4/01/15

Required Date: 4/08/15

Start Qty: 4.00

Required Qty: 4.00

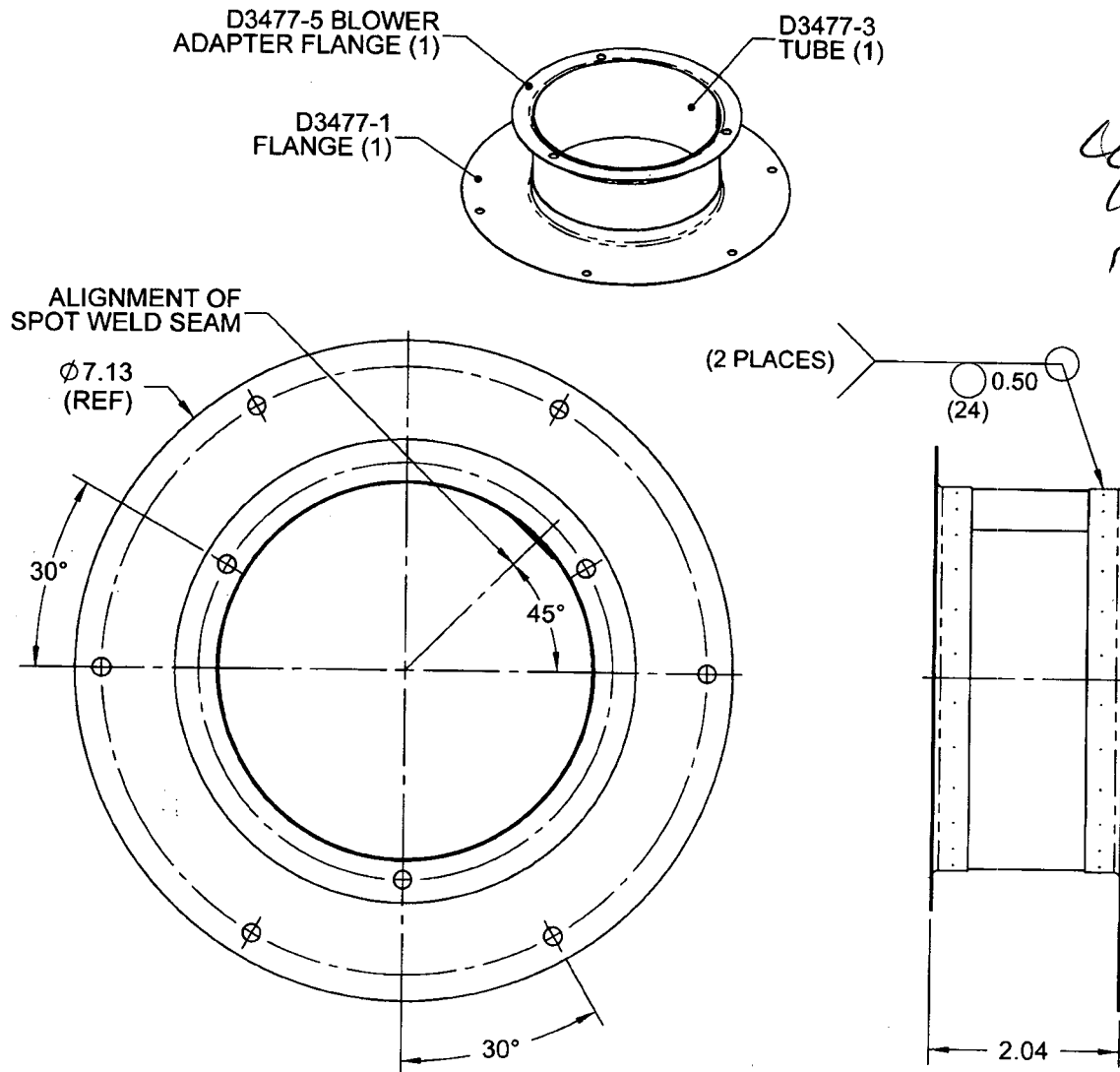
Comments: IPP Rev: A New Issue 06-02-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3477-1 *D3477-1* Flange		Manufactured	No			100	Each	8.0000	1	4			
									**		FF	APR 01 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				Mezz				8					
				65899				3					
				74731				5					
D3477-3 *D3477-3* Tube		Manufactured	No			100	Each	4.0000	1	4			
									**		FF	APR 01 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				Mezz				4					
				46272				4					
D3477-5 *D3477-5* Blower Adapter Flange		Manufactured	No			100	Each	6.0000	1	4			
									**		FF	APR 01 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				Mezz				6					
				46989				6					



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	
B	08.12.19	$\phi 3.40$ & $\phi 4.1$ WERE $\phi 3.600$ & $\phi 4.14$ (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL-S-5019	

RELEASED
8/01/30



D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

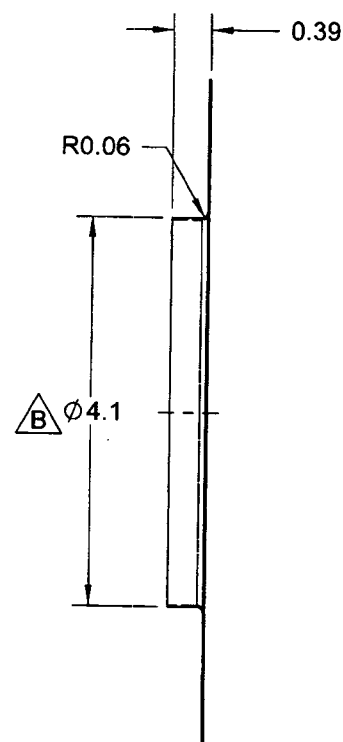
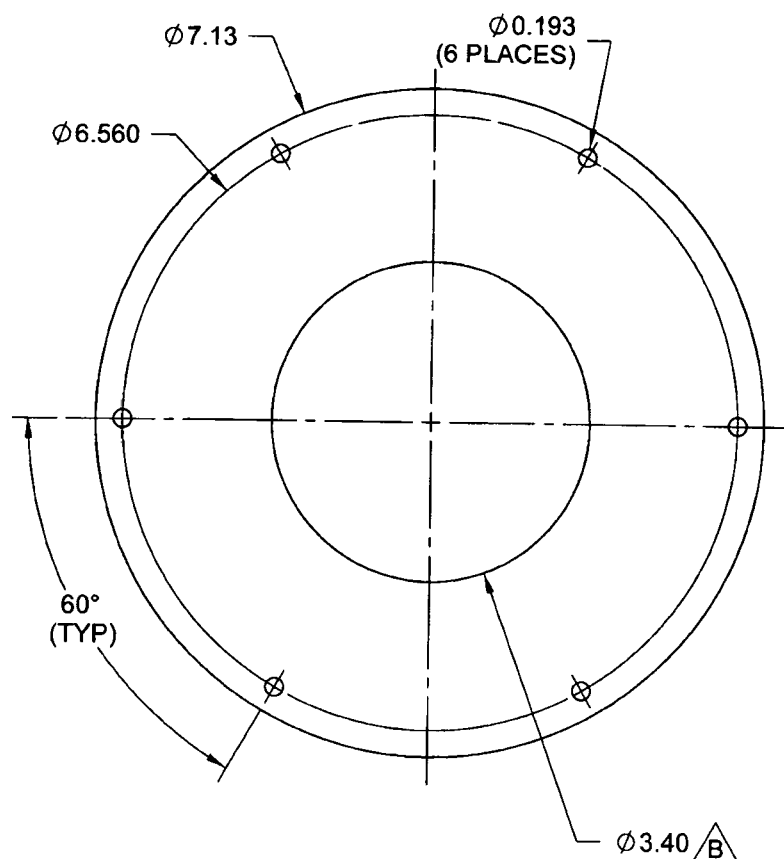
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
9/2/12 MP



**D3477-1F FLANGE
FLAT PATTERN**

**D3477-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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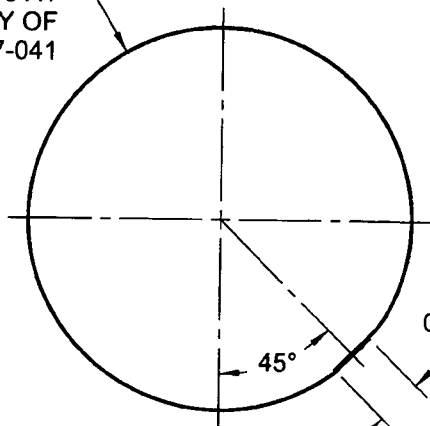
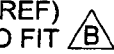
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
9/2/30 11/15

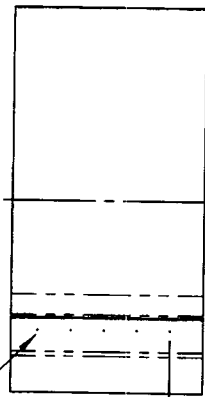
Ø4.10 (REF)
FORM TO FIT
D3477-1/-5 AT
ASSY OF
D3477-041



0.50^{+0.10}_{-0.00} B

45°

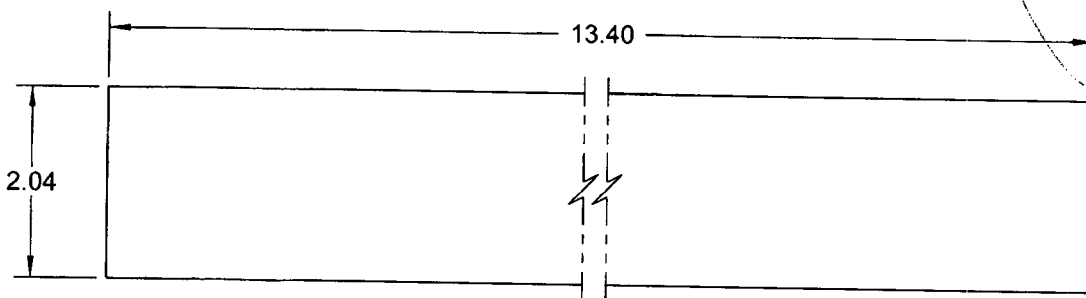
2.04
(REF)



0.35

0.38
(5)

D3477-3 TUBE



D3477-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA) B
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

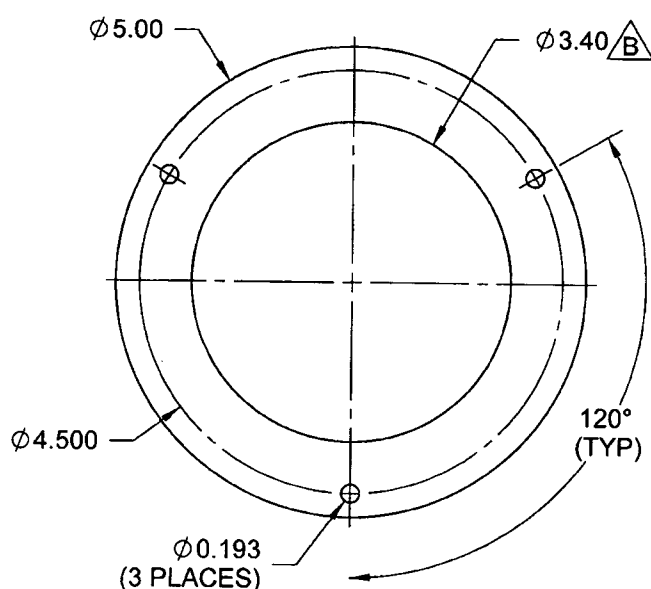
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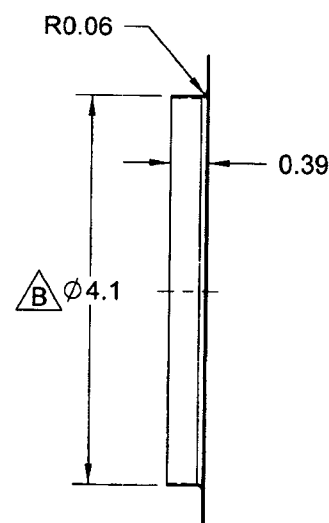


DESIGN <i>b</i>	DRAWN BY <i>b</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>pt</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
8/10/20



D3477-5F FLAT PATTERN



**D3477-5 BLOWER
ADAPTER FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH (B)
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28039**

Purchase Order Date 4/7/2015

PO Print Date 4/24/2015

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	131251	D3477-041 BLOWER MOTOR INLET	4/27/2015		4.00 ✓	\$50.00	\$200.00

Yes

4/27/2015

SPOT WELDING AS PER DWG D3477 REV. B
B131251
AS PER QSI 004

CL 15/04/27

Line Total: \$200.00

PO Total: \$200.00

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 5

Change Date: 4/24/2015



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON /SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
24	04	15	0558762	1/1



VENDU À /SOLD TO

EXPÉDIÉ À /SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART	GFI-0299	0301798	PO28039

QUANTITÉ QUANTITY	N° DE PIÈCE PART NO	DESCRIPTION
----------------------	------------------------	-------------

4 D3477-041 (SPOT WELD ONLY)

BLOWER MOTOR INLET

ITEM 1 -

CY 15/04/27

MFG. JOB# _____ QTY _____

DUE DATE: _____

EXPÉDITEUR
SHIPPER

REÇU PAR /RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.